

Work Order ID 132920

Friday, May 15, 2015 11:39:13 AM

132920

Page 1

Item ID: D2847

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Lug

Stop

NS2

Start Date: 5/15/2015 Start Qty: 12.00

12

Cust Item ID:

Required Date: 5/22/2015 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: mfDate: 5-5-15 Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2847

Rev C

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 6.25" Note: 1 Blank makes 4 parts

12 0 JFL 2015-05-21

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine per folio D2847

12 0 JFL 2015-05-21

120

0.00

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

12 0 JFL 2015-05-21

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Work Order ID 132920

Friday, May 15, 2015 11:39:13 AM

132920

Page 2

Item ID: D2847

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Lug

Start Date: 5/15/2015 Start Qty: 12.00

12

Cust Item ID:

Required Date: 5/22/2015 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

DAS

20

9-89

15-05-21

140

Small Fab

0.00

140

Small Fab

Memo

0.00

Small Fab

Tumble to remove rough edgesDeburr any rough edges after tumbling

C'sink as per Dwg D2847

12

φ

JFC 2015-05-21

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

DAS

38

9-89

12

MAY 22 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY																																																											
☐ Environment	☐ Design	☐ Doc/Data	☐ Equip/Tooling	☐ Handling/Pre	☐ Material	☐ Internal Transport	☐ Tribal Knowledge	☐ LOA	☐ Substation	☐ Past Expiry Date	☐ Misidentified	☐ No Re-verification	☐ Operator	☐ Offset/Setup	☐ Supplier	☐ Training	☐ Use for Testing	☐ Poor Information	☐ Rushing	☐ Product Improvement	☐ Process Improvement	☐ Manufacturing Process	☐ Past Due	☐ Pressure/Forced	☐ Bending	☐ Centre Not Concentric	☐ Cracks	☐ Crimp/Kink/Ripple/Wave	☐ Cuffs	☐ Crushing	☐ Heat Treat	☐ Wave/Twist in Tube	☐ Marks/Chatter	☐ Temperature/Cure	☐ Set-up	☐ BOM/Route	☐ Broken/Damage/Defect	☐ Inspection Incomplete/Unqualified	☐ Contamination	☐ Countersink	☐ Cut Too Short	☐ Instructions Incomplete/Unclear	☐ Drill Holes	☐ Power Loss/Surge	☐ Folio/Program	☐ Grain	☐ Weld	☐ Wrong Stock Pulled	☐ Out of Sequence	☐ Off-set	☐ Misabeled	☐ Fit/Function	☐ Misaligned/off center	☐ Positioned Wrong	☐ Outside Dimensions	☐ Over/Under tolerance	☐ Part Incorrect	☐ Part Lost/Missing	☐ Part Moved	☐ Drawing	☐ Finish	☐ Misread	☐ Turning Sequence
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Work Order ID 132920

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132920

Page 3

Item ID: D2847

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Lug

Stop ***NS2***

Start Date: 5/15/2015 Start Qty: 12.00

12

Cust Item ID:

Required Date: 5/22/2015 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00

160

HandFinish

Memo

0.00

Hand Finishing

(12)

05/05/22

170

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

170

Powdercoat

M 131545.

Memo

0.00

Powder Coating

START TIME:

11:00

OVEN TEMPERATURE:

FINISH TIME:

11:20

12

φ

15-5-25.

05 34 089

180

QC3- Inspect Part Finish

0.00

180

QC

Memo

0.00

Quality Control

(12)

QB
15-05-25

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : _____																						
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Page 4

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Stop

NS2

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12

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Identify as per dwg & Stock Location: 

0.00

190

Packaging

Memo

0.00

Packaging

12

DAS
6
9-89

MAY 25 2015

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

MLJ

MAY 25 2015

 5.25

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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OTHER :																																																																					

Picklist Print

Friday, May 15, 2015 11:39:13 AM

Page 1

Work Order ID: 132920

132920

Parent Item: D2847

D2847

Parent Item Name: Lug

Start Date: 5/15/2015

Required Date: 5/22/2015

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP F00.06.22Removed P/O for powder coatEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.375X02.00 0		Purchased	No			100	f	16.8000	0.1333	2			

M6061T6B0 375X02 000

6061-T6 Bar .375 x 2.00

Location

Loc Qty

Loc Code

MAT001

16.8

M126075

4.8

~~0~~ M129845

12

2 *amt 15/05/21*

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

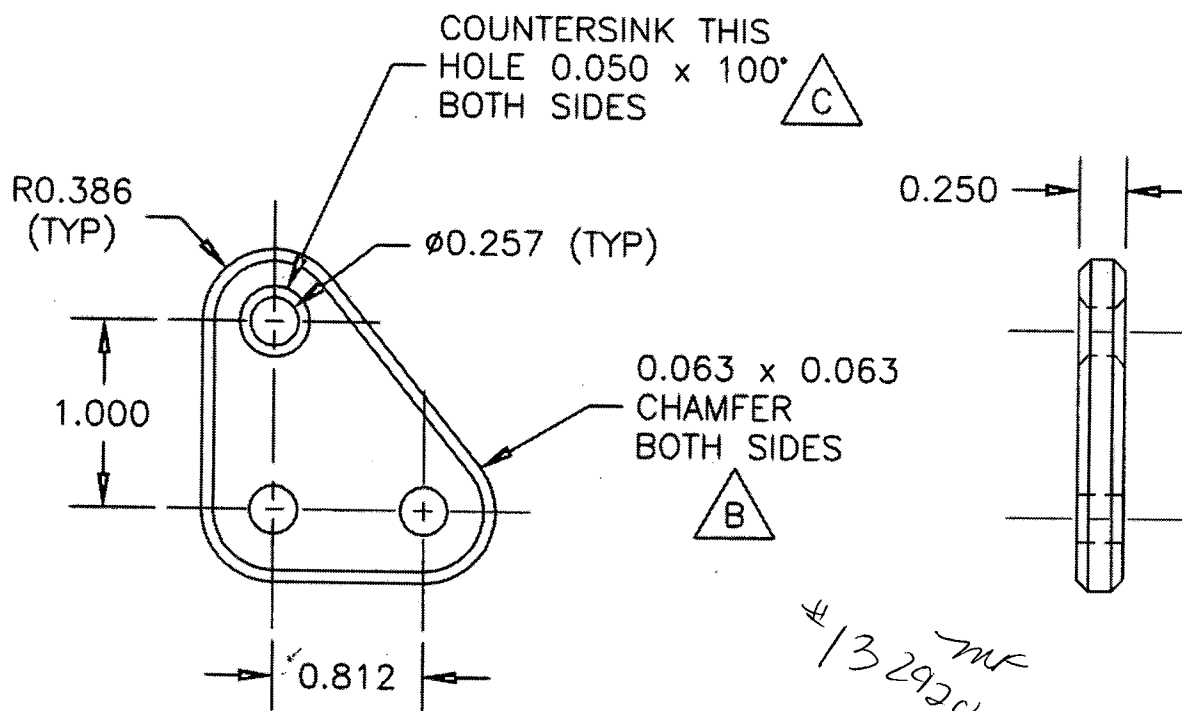
QA Closed: _____ Date: _____ Work Order update only ☐

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DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2847	REV. C SHEET 1 OF 1
DATE 99.02.15		TITLE LUG	SCALE 1:1
A	98.11.04	NEW ISSUE	
B	99.01.07	ADD CHAMFER	
C	99.02.15	ADD COUNTERSINK	

RELEASED
99.02.15 *KE*



MATERIAL: 6061-T6 OR 6061-T651 (QQ-A-225/8 OR QQ-A-200/8 OR QQ-A-250/11)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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